

Work Order ID 62763

Page 1

Thursday, October 07, 2010 3:13:00 PM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10/10/07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A 10/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M111335/M115778

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 10-10-13

BE 10/10/14

BE 10/10/14

BE 10/10/14

DP 10-10-18

W/O:		WORK ORDER CHANGES					
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Stop

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Date:

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Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

(X1)

10/10/19

10/10/19

10/10/19

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

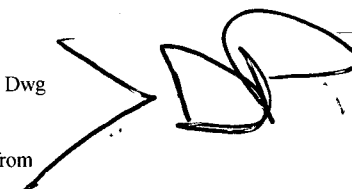
1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 11/5/14 ☐Sikaflex expire date: ☐ 11/01/30 ☐Start: ☐ 10/11/04 ☐ Time: ☐ 9:00 AMFinish: ☐ 10/11/04 ☐ Time: ☐ 2:00 PM

(Adhere for 12 hours)



10-10-19



10/11/04

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Solulus

70

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP

10-11-8

BB

10/11/08

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

L° 24.5°

h 2 2.9125"

S 10/11/08

⑦

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ *m11k385*

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

*BE 10/11/10**BE 10/11/11**BE 10/11/11*

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

*8101111**11*

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/11

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

=) M 10/11/11

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:25
OVEN TEMPERATURE: 3200
FINISH TIME: 1:55

M115291.

1 BK 10-11-15.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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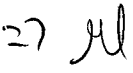





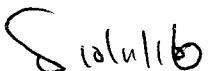

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Work Order ID 62763

Thursday, October 07, 2010 3:13:00 PM

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Item ID:	D206-642-541	Accept		Setup	Start	
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Required Date:	10/15/2010	Req'd Qty:	1.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 27  0.00		1014116		1			
250  HandFinish Hand Finishing	HandFinishing Memo 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> 11109956 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 1115114 Sikaflex expire date: <input type="checkbox"/> 11101	0.00 27  0.00		1014116		1			
260  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Nut Plate & Inserts	0.00  0.00							

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  HandFinish Hand Finishing	HAND FINISHING RESOURCE #1 Memo ✓ 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 ✓ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M115114 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 11/01 ✓ 3-Inspect for foreign objects as per QSI 024 ✓ 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: <u>P/A</u> 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M115114 <input type="checkbox"/> ✓ Sikaflex expire date: <input type="checkbox"/> 11/01	0.00 0.00		10/11/16		1	0		
280  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sisulka					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

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Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube




Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190  Extrusion Round 3" 206		Manufactured	No			110	Each	73.0000	1	1			
<div> <div>Location</div> <div> <div>LG</div> <div>47575</div> <div>59874</div> </div> </div> <div> <div>Loc Qty</div> <div>73</div> <div>25</div> <div>48</div> </div> <div> <div>Loc Code</div> </div>													
D3285-1  Cap		Manufactured	No			110	Each	141.0000	1	1			
<div> <div>Location</div> <div> <div>LG</div> <div>52511</div> <div>52647</div> </div> </div> <div> <div>Loc Qty</div> <div>141</div> <div>74</div> <div>67</div> </div> <div> <div>Loc Code</div> </div>													
D3282-041  Float Web (206L/407)		Manufactured	No			150	Each	2.0000	1	1			
<div> <div>Location</div> <div> <div>LG</div> <div>59886</div> </div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> </div>													

Handwritten initials

10-10-13

Handwritten initials

BE 10/10/14

1

BB 10/10/09

60931

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

65.0000

1

1



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

65

58545

2

60652

4

61496

59

B 63359 (12) BE 10/11/10

D3275-1

Manufactured No

190

Each

216.0000

12

12



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

216

53453

8

61646

102

62399

106

12

12

BE 10/11/10

CR3212-4-03

Purchased No

250

Each

1,888.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1888

111359

5

112314

2

114436

448

114450

71

114859

1362

V2

1

1

D3415-041

Manufactured No

250

Each

52.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST056

52

33842

52

V1

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Shop Packet Print

Page 2

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Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

250 Each

446.0000 2 2



Cherry Rivet



10/11/10

Location

Loc Qty

Loc Code

ST311

446

112314

4

113539

44

113973

398

ALS4-1032-130

Purchased No

250 Each

1,147.000 78 78



Insert



10/11/10

Location

Loc Qty

Loc Code

PKG11

1098

114723

1098

ST282

10

110511

10

ST381

39

114654

39

D3536-15

Manufactured. No

270 Each

21.0000 1 1



Gasket



10/11/10

Location

Loc Qty

Loc Code

FP

9

56055

1

60875

8

FP11

12

59238

1

62459

11

XL

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Shop Packet Print

Page 3

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:05 PM

Page 4

Work Order ID: 62763

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-23

Manufactured No

270

Each

8.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP011

8

B63238

61237

8

D3536-35

Manufactured No

270

Each

23.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP012

23

58683

1

61692

10

62462

12

D3536-39

Manufactured No

270

Each

12.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP12

12

58215

1

58571

11

D3535-15

Manufactured No

270

Each

12.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

12

61241

6

62241

6

B62707

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:05 PM

Page 5

Work Order ID: 62763

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-35

Manufactured No

270 Each

8.0000

1

1



Wearshoe



10/14/16

Location

Loc Qty

Loc Code

FP018

8

B62461

1

60865

8

10/14/16

D3535-39

Manufactured No

270 Each

17.0000

1

1



Wearshoe



10/14/16

Location

Loc Qty

Loc Code

FP18

17

58214

1

60233

16

10/14/16

D3535-23

Manufactured No

270 Each

19.0000

1

1



Wearshoe



10/14/16

Location

Loc Qty

Loc Code

FP

7

61830

7

FP021

20

60231

11

10/14/16

D3537-3

Manufactured No

270 Each

6.0000

1

1



Wearpad



10/14/16

Location

Loc Qty

Loc Code

FP17

6

60866

6

B61674

10/14/16

Thursday, October 07, 2010 3:13:05 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:05 PM

Page 6

Work Order ID: 62763

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

270

Each

14.0000

9

9



Wearpad



10/11/16

Location

Loc Qty

Loc Code

FP

1

BGT313

X9

55465

1

FP017

6

61986

6

FP17

7

57713

3

60491

3

61640

1

AN960C10L

NAS1149C0332
R

Purchased

No

270

Each

29.0000

80

80



washer

115832



X80 10/11/16

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN960C416

NAS1149C0463
R

Purchased

No

270

Each

100.0000

1

1



washer



10/11/16

Location

Loc Qty

Loc Code

ST346

100

100993

100

X115358

vt

Thursday, October 07, 2010 3:13:05 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:05 PM

Page 7

Work Order ID: 62763

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

855.0000

2

2



Phenolic Washer



10/11/16

Location

Loc Qty

Loc Code

ST077

855

42329

150

52505

705

x2

AN3C4A

Purchased

No

270

Each

1,650.000

80

80



10/11/16

BOLT

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

42

115438

42

ST350

1588

114108

14

114416

12

114523

2

115300

560

115589

1000

x80

AN4C5A

Purchased

No

270

Each

489.0000

1

1



10/11/16

BOLT

Location

Loc Qty

Loc Code

ST346

489

110552

4

112243

485

x1

Thursday, October 07, 2010 3:13:05 PM

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Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 07, 2010 3:13:05 PM

Page 8

Work Order ID: 62763

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

44.0000

1

1



Aft Cap



10/14/10

Location

Loc Qty

Loc Code

FP-4

39

57332

39

fp5

1

61752

1

FP6

4

52663

4

D3413-1

Manufactured No

270

Each

31.0000

1



Ring



10/14/10

Location

Loc Qty

Loc Code

ST473

31

51586

1

53446

15

61322

15

Thursday, October 07, 2010 3:13:05 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

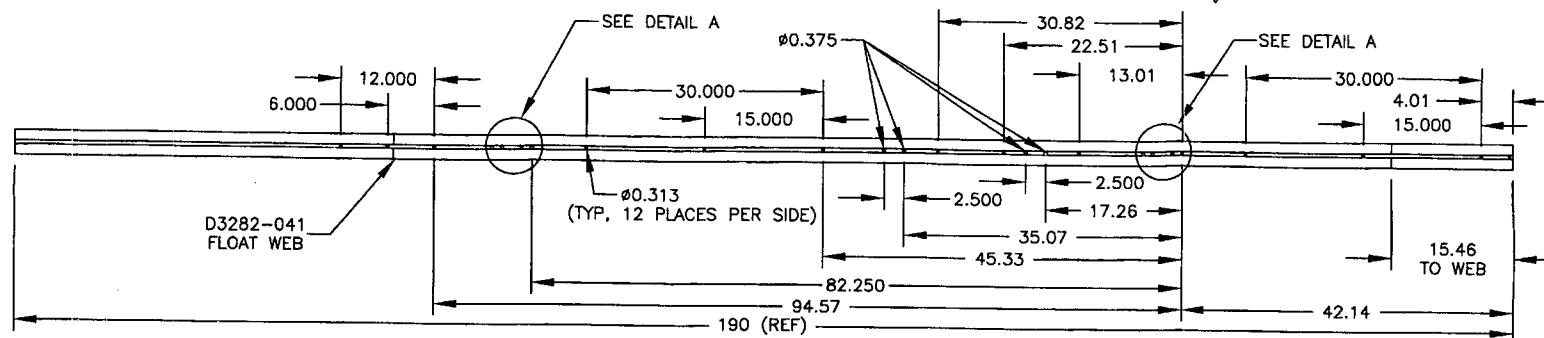
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

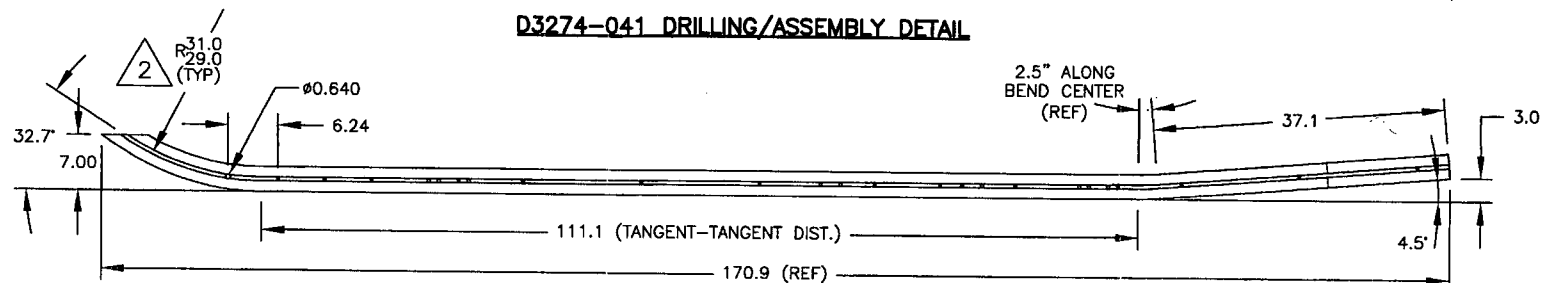
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

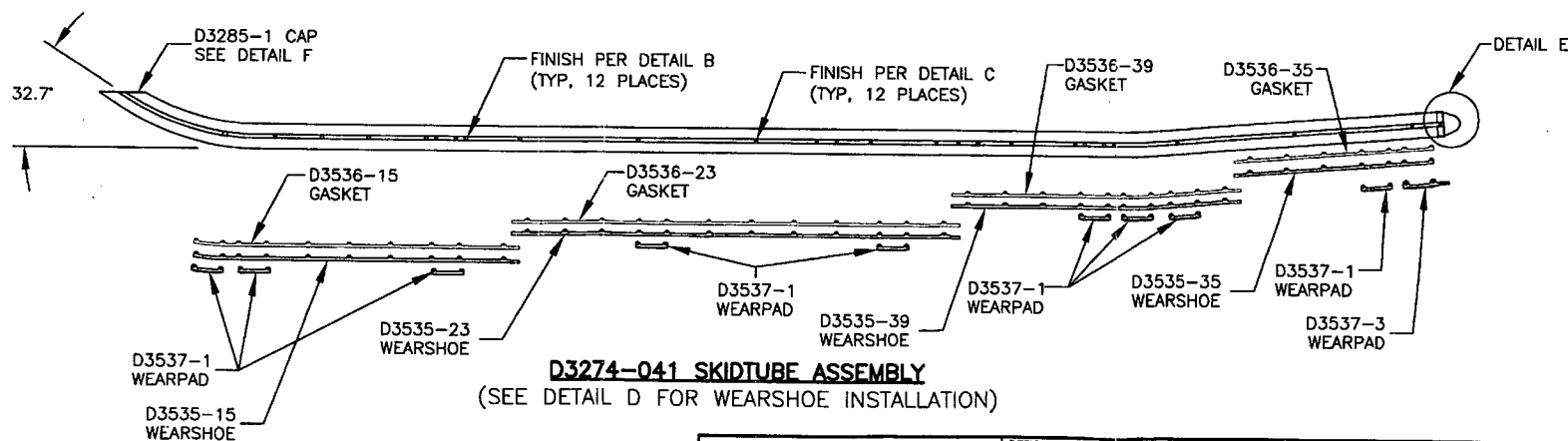
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED #	APPROVED #	
DATE 06.12.19	DRAWING NO. D3274	REV. D SHEET 2 OF 4
TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

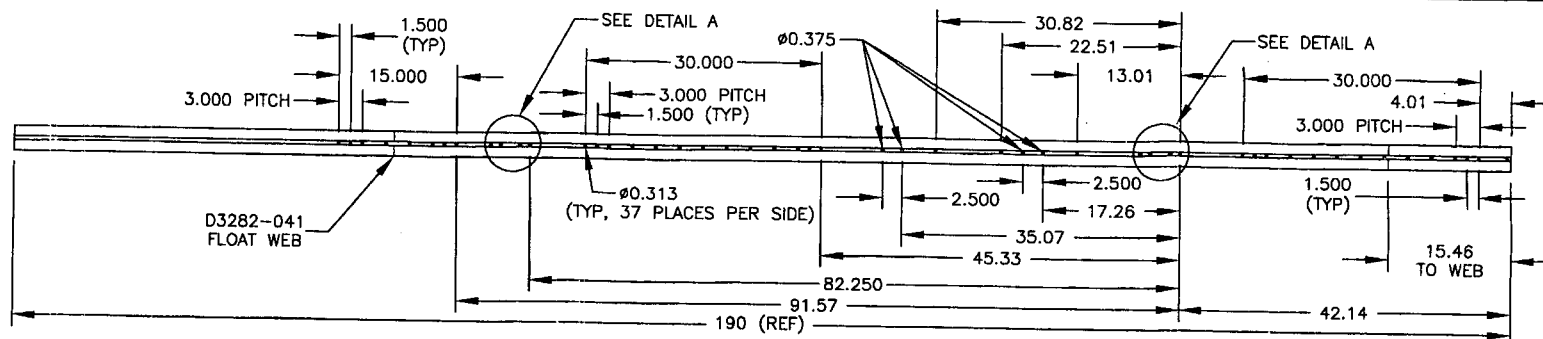
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

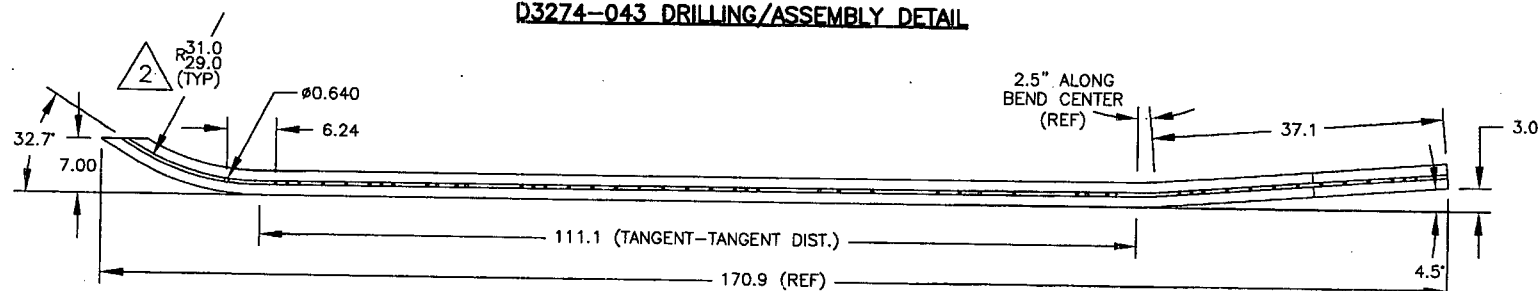
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

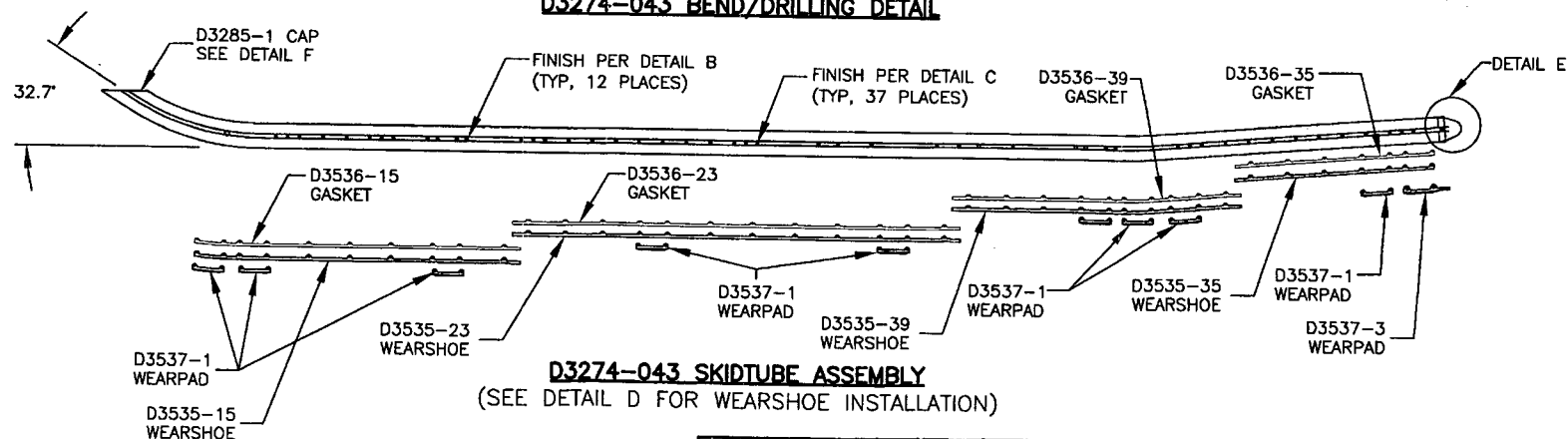
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		
		REV. D SHEET 3 OF 4 SCALE 1:15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

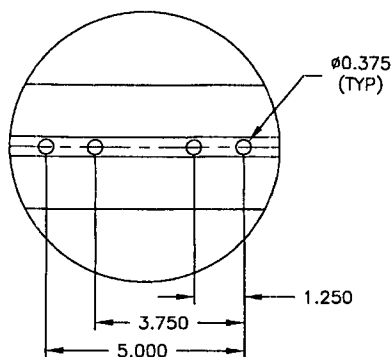
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

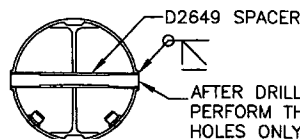
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

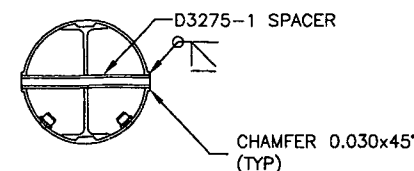


DETAIL B FOR 0.375 HOLES ONLY

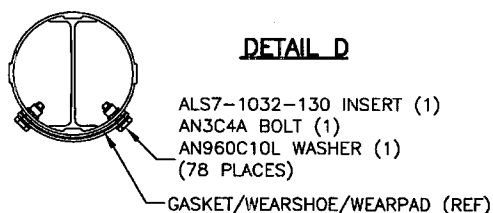


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

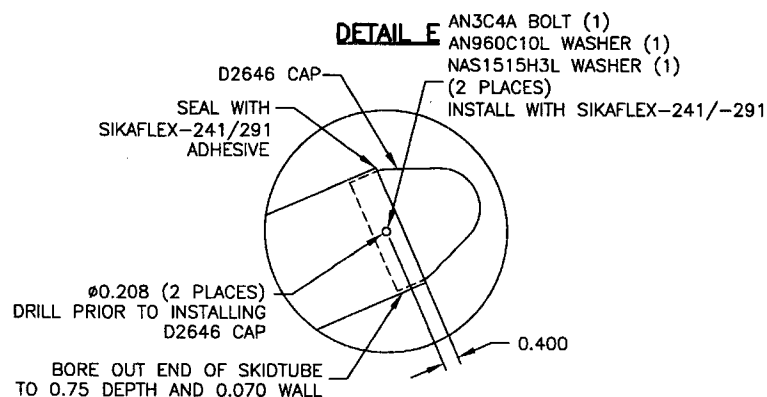
DETAIL C FOR 0.313 HOLES ONLY



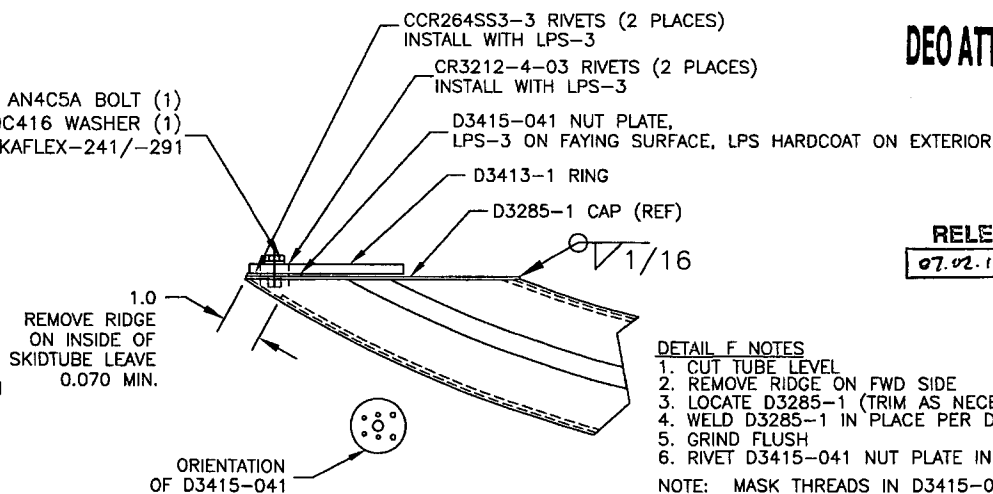
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

- DETAIL F NOTES
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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		DATE	06.12.19	TITLE		SKIDTUBE ASSEMBLY	
						SCALE 1:3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

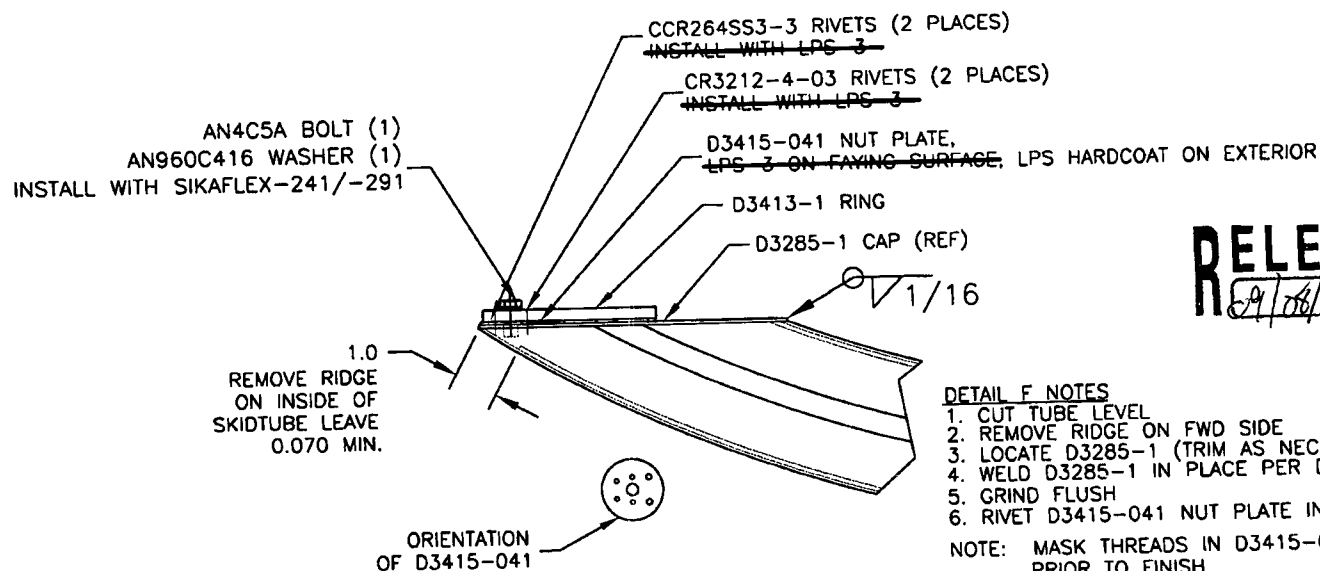
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN UP	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS."~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622508
Part number: D206-442-541
Description: 206 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier D.J.D. Date of Test Coupon 10.09.30

Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.